Monday, 1/8/2007 11:08:43 AM User: Kim Johnston **Process Sheet** : BUSHING Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 30198 : 10175 **Estimate Number** : NIA : D2570 Part Number P.O. Number S.O. No. : 1) M : 1/8/2007 D2570 REV A **Drawing Number** This Issue Prsht Rev. **Project Number** : N/A : WIA : MACHINED PARTS Type **Drawing Revision** First Issue : 29776 Material **Previous Run** 500 Um: : 1/20/2007 Each Qty: **Due Date** Written By Checked & Approved By Re-format; Removed finishing; Material change K : Est E 02,08.29 Comment j **Additional Product** Job Number: **Description:** Seq. #: Machine Or Operation: M303R0750 303 Round Bar .75" 1.0 scrap & parts 10" No good. M 103503

scrap 3 parts of 10" No good M1023.

Storlor Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>4103503</u> 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPEC PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

	WORK ORDER C	HANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP		STEP PROCEDURE CHANGE By			Approval

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA	Date: 07/03/0
			QA: N/C Closed	: Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B		Corrective Action Section B			Ammaya
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
· _ · · · · · · · · · · · · · · · · · ·								

NOTE: Date & initial all entries

Date: User:

Monday, 1/8/2007 11:08:43 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 30198

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	e Ltd							
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									:
Part No	:	PAR #:	Fault Cate	gory: NC	R: Yes	No DQ	A :	Date:	
					QA: N/	C Close	d:	Date:	
NCR:		V	VORK ORDI	ER NON-CONFORMANC	E (NCR)			
D.4.T.E.		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
•					;	-			:
							,		·
		,							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30198
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	,804	1			
0.060	+/-0.005	.063	1			
R0.010	+0.010/-0.000	.010	1			
Ø0.425	+0.000/-0.002	,424	1			
Ø0.257	+0.005/-0.000	,260	/			
Ø0.750	+/-0.010	.745	\checkmark			
0.030 x 20°	+/-0.010	,630 y 20°	\checkmark			
		,				

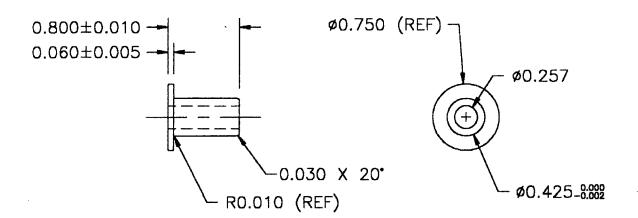
Measured by:	Audited by:	MS.	Prototype Approval:	N/A
Date: 67/02/27	Date:	<u>ज्यान्त्र</u>	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	· **



DESIGN	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,	LTD CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
4	\mathcal{A}	D2570	SHEET 1 OF 1
DATE		THE .	SCALE
96:09:16		BUSHING	1:1

RELEASED



BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 - 0.75 DIA STOCK

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER